

Date: Friday, 11/18/2005 6:54:49 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BEARPAW KIT (19"X48")	
Job Number	: 24834				
Estimate Number	: 10768				
P.O. Number	: N/A		Part Number	: K10015	
This Issue	: 11/18/2005 S.O. No. : N/P		Drawing Number	: D2521 REV 1	
Prsh Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: N/A	
Previous Run	: N/A		Material	: N/A	
Written By	: See Comment below		Due Date	: 11/30/2005	
Checked & Approved By	: See Comment below		Qty:	10 kits	
Comment	: Est Rev:D 05.06.20 Forming removed KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		Comment: DOCUMENT CONTROL Photocopy bluefile: K10015 D205-564-011 D430-688-011 and create labels per PPP K10015 CHG002 (Bag Bluefiles separately) DH 05/11/28 (10)
2.0	MUHMWB10	UHMW 1" Black

3.0	HAAS1	(8) (12) HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 1-Inspect material for defects or damage prior to machining D2521 2-Machine as per Folio and Dwg D2521 Identify as D2521 3-Deburr Rep 05/11/26 10
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WO:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X48")

Job Number: 24834

Part Number: K10015

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



En 05/126 10

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8

SECOND CHECK



En 05/126 10

Comment: SECOND CHECK

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0 D2182B055

Clamp Cushion, Black



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1/8/18 D2182B055 Rubber Cushion B23172

8/0 D2274

Radius Block



Comment: Qty.: 16.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1/8/18 16 D2274 Radius Block B24066
2 D2521(ref only) Bearpaw B24834
8 D2947 Cimp B23188

9.0 D2529

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 D2529 Washer B23177

10.0 AN415A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Drawing Name: BEARPAW KIT (19"X48")

Job Number: 24834

Part Number: K10015

Job Number:



Seq. #: Machine Or Operation:

Description :

16 AN4-15A Bolt M17566

11.0 AN960JD416 Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416 Washer M18136

12.0 MS21042L4 Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 80.0000 Each(s)

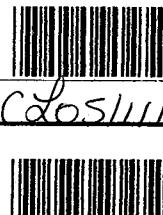
Pick: Packing Kit

Qty Part Number Description Batch

16 MS21042L4 Nut (or -4) M17997

10/05/11/28 10 ADIG 189

13.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPK10015

Location: PPV01

10/05/11/29 10

15.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(10/05/11/30 10)

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

0000000000

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No : 0024834
Project Name : K10015
Project For : WK548
Work Order Type : Main
Main WO Number :
House Part Number : *K10015
Description : Bearpaw Kit
Manufactured : Yes
Amount Req'd : 5
Amount Done : 0
Start Date : 11-17-05
Est Finish Date : 11-30-05
Act Finish Date :
Drawings Reqd : No
Ok for Approval :
Approval Rec'd :
Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss)	0.00	0.00

DART AEROSPACE LTD

Work Order:

24834

Description: Bearpaw

Part Number:

D2521

Inspection Dwg: D2521

Rev: I

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	1.00	+/-0.030	1.002	—		
B	5.60	+/-0.030	5.574	—		
C	11.50	+/-0.030	11.50	—		
D	10.250	+/-0.010	10.259	—		
E	13.250	+/-0.010	13.250	—		
F	8.500	+/-0.010	8.510	—		
G	22.13	+/-0.030	22.125	—		
H	8.75	+/-0.030	8.754	✓		
I	44.50	+/-0.030	44.52	—		
J	6.69	+/-0.030	6.697	—		
K	5.63	+/-0.030	5.619	—		
L	7.000	+/-0.030	7.002	✓		
M	5.000	+/-0.010	5.005	—		
N	4.00	+/-0.030	4.001	✓		
O	6.63	+/-0.030	6.637	—		
P	19.00	+/-0.030	19.00	✓		
Q	0.31 x 45°	+/-0.030	0.31 x 45°	✓		
R	0.19 x 45°	+/-0.030	0.19 x 45°	✓		
S	0.50 x 45°	+/-0.030	0.50 x 45°	✓		
T	0.38 x 45°	+/-0.030	0.38 x 45°	✓		
U	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓		
V	Ø0.260	+0.005/-0.000	0.260	✓		
W	Ø0.93	+/-0.030	0.929	✓		
X	0.30	+0.030/-0.010	0.304	✓		
Y	0.37	+0.030/-0.010	0.387	—		
Z	0.75	+0.030/-0.010	0.763	—		
AA	0.25	+0.030/-0.010	0.264	—		
AB	4.00	+/-0.030	4.006	✓		
AC	6.62	+/-0.030	6.625	✓		
AD	0.95	+0.030/-0.010	0.962	✓		
AE	0.37	+0.030/-0.010	0.384	✓		
AF	3.40	+0.030/-0.010	3.40	✓		
AG	6.63	+/-0.030	6.625	—		

Measured by:	EP
Date:	05/11/22

Audited by:	JL
Date:	05/11/22

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10015	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	✓

DART AEROSPACE LTD	Work Order:	
Description: Bearpaw Kit (48" x 19") 205/430	Part Number:	K10015
Dwg: D2521 Rev. I	Qty:	Kits
Ref: K10015 Rev. A; DSK086-6 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																								
1	DC	Issue Traveler Note: (1) K10015 Kit consists of Qty (2) D2521 Dwg not required																																											
2	DC	Photocopy bluefile: K10015 D205-564-011 D430-688-011 and create labels per PPP K10015 CHG002 REFERENCE ONLY (Bag Bluefiles separately)		-																																									
3	GA	Cut 2 blanks per (1) K10015 Kit Cut blank: 19.50" x 48.00" x 1.00" thick (+0.030/-0.000) per DSK086-6 Material: Black UHMW 1" (MUHMWB10) Batch: _____																																											
4	MV	Inspect material for defects or damage prior to machining																																											
5	MV	Machine as per Folio FA222 and Dwg D2521 Identify as D2521 Dwg Rev: _____ Folio Rev: _____																																											
6	QC2	Inspect parts as they come off the CNC machine																																											
7	MV	Deburr																																											
8	QC8 & 5	Second inspection																																											
9	KP	Pick: Packing Kit (Note: D2521 is on the BOM as material from step 3) <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>8</td> <td>D2182B055</td> <td>Rubber Cushion</td> <td>_____</td> </tr> <tr> <td>16</td> <td>D2274</td> <td>Radius Block</td> <td>_____</td> </tr> <tr> <td>2</td> <td>D2521</td> <td>Bearpaw</td> <td>_____</td> </tr> <tr> <td>16</td> <td>D2529</td> <td>Washer</td> <td>_____</td> </tr> <tr> <td>8</td> <td>D2947</td> <td>Clamp</td> <td>_____</td> </tr> <tr> <td>16</td> <td>AN4-15A</td> <td>Bolt</td> <td>_____</td> </tr> <tr> <td>16</td> <td>AN960JD416</td> <td>Washer</td> <td>_____</td> </tr> <tr> <td>16</td> <td>MS21042L4</td> <td>Nut (or -4)</td> <td>_____</td> </tr> <tr> <td>1</td> <td>Paperwork package from Step 2</td> <td></td> <td>_____</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	8	D2182B055	Rubber Cushion	_____	16	D2274	Radius Block	_____	2	D2521	Bearpaw	_____	16	D2529	Washer	_____	8	D2947	Clamp	_____	16	AN4-15A	Bolt	_____	16	AN960JD416	Washer	_____	16	MS21042L4	Nut (or -4)	_____	1	Paperwork package from Step 2		_____			
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1	Paperwork package from Step 2		_____																																										
10	QC4	Inspect Kit for 100% Completeness on the W/O																																											
11	PK	Identify and pack for shipping as per PPP K10015																																											
12	AC	Cost / part: _____																																											
13	DC	Close W/O Inspect Level 21																																											

Rev	Date	Change	Revised By	Approved
A	01.10.16	K10015 created for Bearpaw Kit (MPP 2164)	SM	
B	03.05.26	Reformat; Incorporated D2521	KJ/RF	
C	04.02.17	Tolerance added to Step 3	KJ/JLM	
D	05.06.20	Forming removed	KJ/JLM	